DEBURR

		DQA: Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	

									QA Closed:	Date:	
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data				***							
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process	_										
Supplier											
Training											
Unapproved											
					F	AULT CAT	GORY				
Landir	ng Gear			_	General			_	•		_
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to (o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
,	Cracks			ļ	Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Instruc	tions Incomplete,	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination	Maint	enance		Part Moved		
1	Heat Trea	at			Countersink	Mislab	eled		Positioned V	Vrong	-
ļ	Inspection		Tube		Cut Too Short	Misrea			Power Loss/	Surge	Other
	Ripples in				Drill Holes	Offset					
	Torque W	/aves in E	xtrusion	ո _	Drawing	Out of	Calibration				
	Turning S	•			Finish	Out of	Sequence				
	Wave/Tw	ist in Tub	e		Folio	Outsid	e Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 107938 *107938* October-07-13 9:02:45 AM Item ID: D4016-1 Accept *N900040100* Setup Start **Revision ID:** Stop Hinge Half, Base Item Name: **Start Date:** 10/07/13 Start Qty: 4.00 **Cust Item ID: Req'd Qty:** 4.00 Required Date: 10/07/13 **Customer:** Reference: Run **Approvals:** Process Plan: Date: Tooling: Date: QC:___ SPC (Y/N): Date: Date: Sequence ID/ Operation Tool ID Tool # Plan Reject Set Up/ Accept Reject **Work Center ID** Description Qty **Run Hours** Code Qty Number Stamp 120 QC2- Inspect parts off machine FAI/FAIB 0.00 SL13-10-20 lle Ø *120* OC 0.00 Memo

120 QC Quality Control

130

160

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

B/10/20 16 Ø

Identify as per dwg & Stock Location: WACCA

160 Packaging

Packaging

Memo

0.00

16x 28 13-10-21

Insp.

Page 2

DQA: Date: ___ MANCE / UPDATE

NCR: Yes / No WORK (ORDER NON-CONFORM
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					<u>. </u>				QA Closed:	Date	:
Work Order	r:		<u> </u>		DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	0				Rework Scrap Use-as-is Work Order Update	- 1	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
onapproved 1	<u> </u>	1	1		F	AULT CATE	GORY		1,		
Landin	g Gear				General				<u> </u>		
	Bending Centre No Cracks Crushed/o Cuffs Heat Trea	Crimped. it n Strip in		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short	Instruc Mainto Mislabo Misrea	ion Incomplete tions Incomplete, enance eled	/Unclear	Ovalized Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
-	Ripples in			<u> </u>	Drill Holes	Offset					
-	Torque W			ⁿ _	Drawing		Calibration				
-	Turning S Wave/Tw				Finish Folio		Sequence e Dimensions				

Work Order ID 107938 Page 3 October-07-13 9:02:45 AM Item ID: D4016-1 Accept *N900040100* Setup Start **Revision ID:** Hinge Half, Base Item Name: Start Qty: 4.00 **Start Date:** 10/07/13 **Cust Item ID:** Required Date: 10/07/13 **Req'd Qty:** 4.00 **Customer:** Reference: Process Plan: Date: **Tooling:** Approvals: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Tool ID Tool # Plan Reject **Operation** Set Up/ Accept Reject Insp. Work Center ID 13/10/21. MF 13-10-21 Description Number Stamp **Run Hours** Code Qty Qty 170 QC21- Final Inspection - Work Order Release 0.00 *170* QC 0.00 Memo

Quality Control

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-O	CONFO	RN	MANCE / UPDATE	•	4	
									QA Closed:	Date:	
Work Orde	ar.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update	Th	۱ erm	Skid-tube Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initia	al	Action	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief E	ng	Description	Date	Verification	QC Inspector
Doc/Data							1				
Equip/Tooling											
Operator			İ			1					·
Material											
Setup											
Other											
Process											
Supplier											
Training										1	
Unapproved			<u> </u>								
					F	AULT CA	ATEC	GORY			
Landi	ng Gear			<u></u>	General				- -		-
	Bending				Bend	Gra	in		Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hard	dwa	re	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ecti	on Incomplete	Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Inst	ructi	ions Incomplete/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Ma	inte	nance	Part Moved		,
	Heat Trea	at			Countersink .	Mis	labe	led	Positioned \	V rong	

Misread

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-07-13 9:02:44 AM

Work Order ID:

107938

Parent Item:

D4016-1

Parent Item Name:

Hinge Half, Base

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD 10.02.22 verified by:EC

IPP Rev:B as per dwg REV.A DD

Component Item ID/ Item Name	Replacement Item ID	•	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	25.3600	0.08	0.32			
304 bar 1.00 x 1.00													V
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT050		25.36							•
				M12	26097	0.38						i.	
				MI	26724	24.98			1.3	5 36	$c \sim 2$	عاء ⁵ 10ھ	آ <i>حا</i> ا-د

											DQA:	Date:	
NCR: Y	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			
										·· 	QA Closed:	Date:	<u>-</u>
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orac	-					Rework			Skid-tube	Crosstube]	Water Jet	Engineering
Part N	No.					Scrap		ļ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No.					Work Order Update]		Large Fab	Composite]	Supplier	
												-	
Root			1		Descri	ption of work order update		Initial	Ad	ction	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator			İ										
Material			j										
Setup													
Other										•			
Process													
Supplier													
Training													
Unapproved													
					•	F	AUI	LT CATE	GORY				
Landi	ing C	ear				General		_		· .	_		_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
1	1		_			1		L			1		l

L	Bending	JBena		Grain	\bigsqcup^{\prime}	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld
L	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	7	Maintenance		Part Moved	
	Heat Treat	Countersink		Mislabeled		Positioned Wrong	_
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset			
	Torque Waves in Extrusion	Drawing		Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			
	Wave/Twist in Tube	Folio		Outside Dimensions			

DART AEROSPACE LTD	Work Order:	107938
Description: Hinge Half, Base	Part Number:	D4016-1
Inspection Dwg: D4016 Rev: A		Page 1 of 1

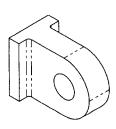
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	e871	V		SLUS	Vern
0.25	+/-0.030	0241				
0.38	+0.030/-0.000	. 241 . 390	/			
R0.03	+/-0.030	.030	/			
0.13	+/-0.030	.125	V			
0.88	+/-0.030	.878				
Ø0.257	+0.006/-0.001	.259	V			
R0.38	+/-0.030	.380 .4995	/			
0.500	+/-0.030	.4995	✓		_\/_	
0.75	+/-0.030	o754	V		V	
-						

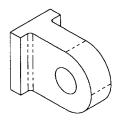
Measured by:	S	Audited by:	770	Preliminary Approval:	
Date:	13-10-20	Date:	13/10/20	Date:	

Rev	Date	Change	Revised by	Approved
Α	10.06.07	New Issue	KJ 😽	

D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



107938 MCJ

D4016-5 HINGE HALF, LIGHT LID

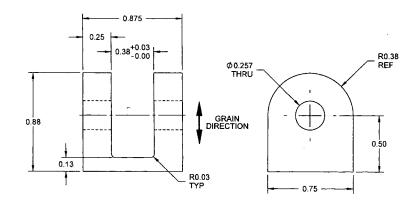


Α	NEWIS	ISSUE JPH 10.01.29			
REV.		DESCRIPTION BY			DATE
DESIG	N	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAW	N	AJS			
CHECK	ŒD	00	DRAWING NO.		REV. A
MFG. A	PPR.	77	D4016	_	SHEET 1 OF 2
APPRO	VED	140	TITLE		SCALE
DE API	DE APPR.		BASKET HINGE		NTS
DATE	10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOCUMENT IS PRIVATE OF CONTROL AND EMPIRED ON HE EMPESS CONCIDENTATO IS NOT TO BE USED FOR ANY PURPOUS ON CONED OF COMMERCATED TO ANY OTHER PERSON WITHOUT WITHIN PRIVATED FROM DART ADDRESSES, LTD.		

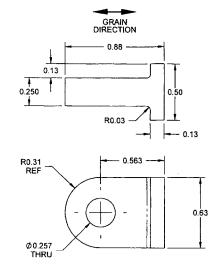
107938

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С



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID **D4016-5 HINGE HALF, LIGHT LID**



DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	77	D4016	SHEET 2 OF 2
APPROVED	100	TITLE	SCALE
DE APPR.	-#	BASKET HINGE	NTS
DATE 10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIMATE AND CONFIDENTIAL AND IS SUPPLED ON THE EURESS CONCINTON THAT IT IS NOT TO BE USED FOR ANY TURNOSS OF ICOMPRISON COMMUNICATION TO MY OTHER PLUGON MYTHOUT	

NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B

REF DART SPEC M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs
-5: 0.01 lbs